

Work Order ID 110103

December-17-13 9:15:03 AM

110103

Page 1

Item ID: D3294-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket For Interior Window For -115
 Start Date: 12/17/13 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 13-12-19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3294	D								

100 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3294
 CUi File D3294-3
 Dwg Rev: D
 Prog Rev: D
 *grain direction on a 45 deg as per dwg**
 2-Deburr if necessary
 110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

6 0 Ae 14.02.08
 6 0 Ae 14.02.08

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Quality Control

DAS
27
989
14/2/8

**DAS
30
9-89**

DAS
27
9-89

4/2/25

14/02/24

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Item ID: D3294-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket For Interior Window For -115
Start Date: 12/17/13 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 12/17/13 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00				<u>7</u>	<u>6</u>	<u>26014.37</u>	
150									
HandFinish	Memo	0.00							
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00				<u>6x</u>		<u>14/03/07</u>	DAS 36 9-89
160									
QC	Memo	0.00							
Quality Control									
170		0.00				<u>6x</u>		<u>14/03/07</u>	DAS 36 9-89
170									
Small Fab	Memo	0.00							
Small Fab	1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294								

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Item ID: D3294-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket For Interior Window For -115

Start Date: 12/17/13

Start Qty: 5.00

5

Cust Item ID:

Required Date: 12/17/13

Req'd Qty: 5.00

5

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

190

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

190

Powdercoat

Powder Coating

Memo

Start Time: 8:45

Oven Temperature: 320°

Finish Time: 9:15

0.00

DAS
27
9-89

0.00

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

Work Order ID 110103

110103

Page 5

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Item ID: D3294-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket For Interior Window For -115

Start Date: 12/17/13 Start Qty: 5.00 *5*

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 5.00 *5*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

Identify as per dwg & Stock Location 8208A 0.00

210

Packaging

Memo

0.00

Packaging

6X 14-3-10

DAS
26
9-89

220

QC21- Final Inspection - Work Order Release 0.00

220

QC

Memo

0.00

Quality Control

MLD 14-03-11

14-03-10

Picklist Print

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Page 1

Work Order ID: 110103

Parent Item: D3294-1

Parent Item Name: Bracket For Interior Window For -115

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP A04.08.24New issueKJ/JLM
IPP Rev:B Now On Waterjet 07-03-26 JLM
IPP Rev:C 08-07-16 . Redesign part DD verified by:EC
IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080 2024-T3 .080 sheet		Purchased	No			100	sf	138.5690	1.8	9.473684		14.02.08	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT022		138.569							
				M127668		138.569							
* D3294-5 Doubler		Manufactured	No			170	Each	8.0000	1	5		14/03/06	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		8							
				104569		8							
MS20470AD4-5 RIVET, UNIVERSAL HEAD		Purchased	No			170	Each	2,104.0000	15	75		14/03/06	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		200							
				m126926		200							
				ST336		1904							
				125654		9							
				m126926		1895							

DART AEROSPACE LTD		Work Order:	110103
Description: Bracket Assembly		Part Number:	D3294-1
Inspection Dwg: D3294	Rev: D	Page 1 of 1	

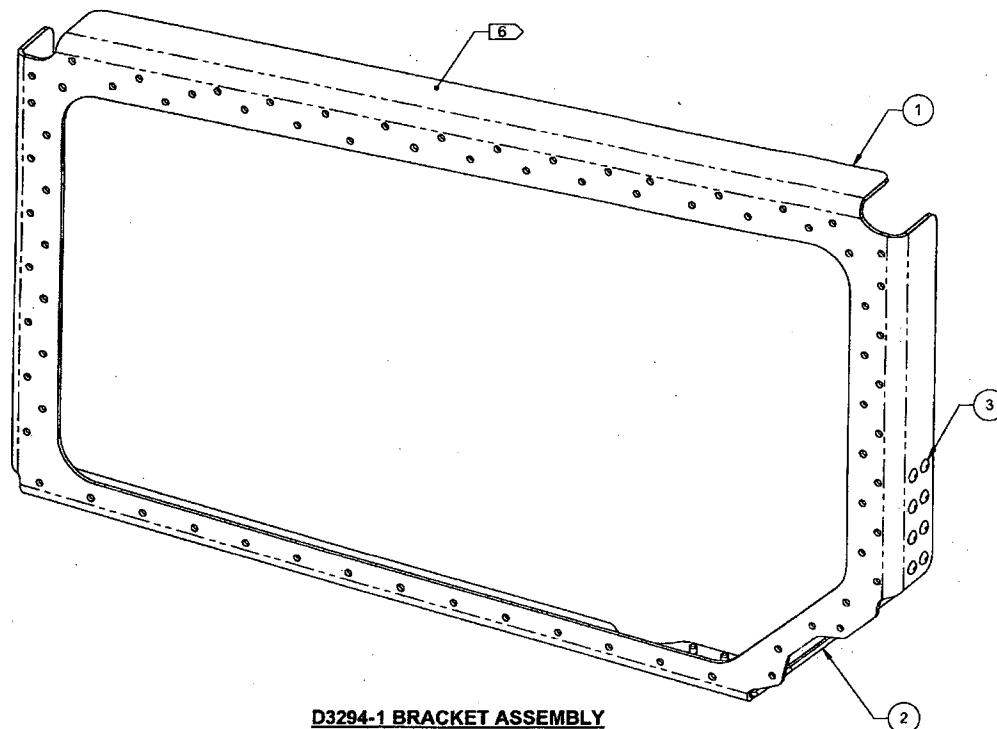
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.128	-		✓	Okm-05
Ø0.141	+0.005/-0.001	.141	-		✓	
6.708	+/-0.010	6.708	-		✓	
1.118	+/-0.010	1.118	-		✓	
5.590	+/-0.010	5.590	-		✓	
1.118	+/-0.010	1.118	-		✓	
13.563	+/-0.010	13.563	-		T	Okm-06
1.043	+/-0.010	1.043	-		✓	
0.625	+/-0.010	.625	-		✓	
0.325	+/-0.010	.325	-		✓	
0.300	+/-0.010	.300	-		✓	
0.400	+/-0.010	.400	-		✓	
6.000	+/-0.010	6.000	-		✓	
1.000	+/-0.010	1.000	-		✓	
17.124	+/-0.010	17.124	-		T	
16.13	+/-0.030	16.13	-		T	
7.27	+/-0.030	7.27	-		T	
11.97	+/-0.030	11.97	-		T	
8.37	+/-0.030	8.37	-		T	
20.05	+/-0.030	20.05	-		T	
12.98	+/-0.030	12.98	-		T	
14.59	+/-0.030	14.59	-		T	
11.66	+/-0.030	11.66	-		T	
0.080	+/-0.010	.079	-		✓	

Measured by: Ac	Audited by: DAS	Preliminary Approval:
Date: 14.02.08	Date: 27 9-89 14/2/10	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	
F	13.05.08	Dwg Rev updated	KJ	

ITEM	QTY	P/N	DESCRIPTION
	X	D3294-1	BRACKET ASSEMBLY
1	1	D3294-3	BRACKET
2	1	D3294-5	DOUBLER
3	15	MS20470AD4-5	RIVET



D3294-1 BRACKET ASSEMBLY

110103 MJS
13-12-19

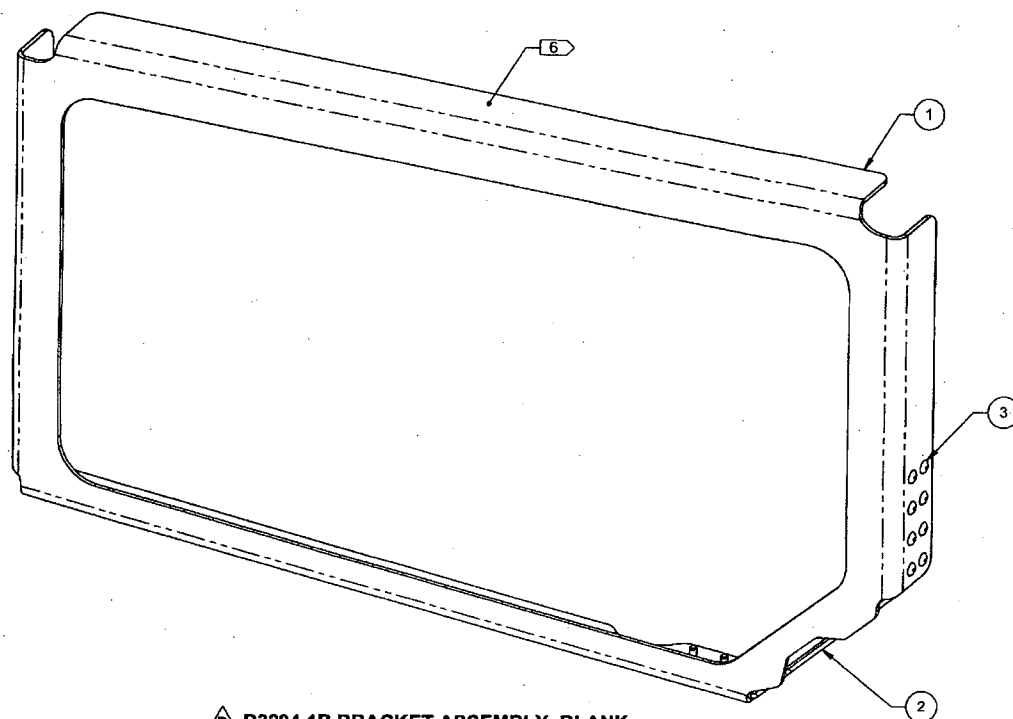
RELEASED
2012-11-21

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1" PER DART QSI 044 6.1
- 7) WEIGHT: 0.83 lbs

D	ADD D3294-1B/3B/3FB. REASON: PAR12-223.	MB	12.11.15
C	REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET 5+6	HS	09.03.24
B	CHANGE FLANGE FROM OUTSIDE TO INSIDE, ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	HS	08.09.22
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3294	SHEET 1 OF 9
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ITEM	QTY	P/N	DESCRIPTION
	X	D3294-1B	BRACKET ASSEMBLY, BLANK
1	1	D3294-3B	BRACKET
2	1	D3294-5	DOUBLER
3	15	MS20470AD4-5	RIVET



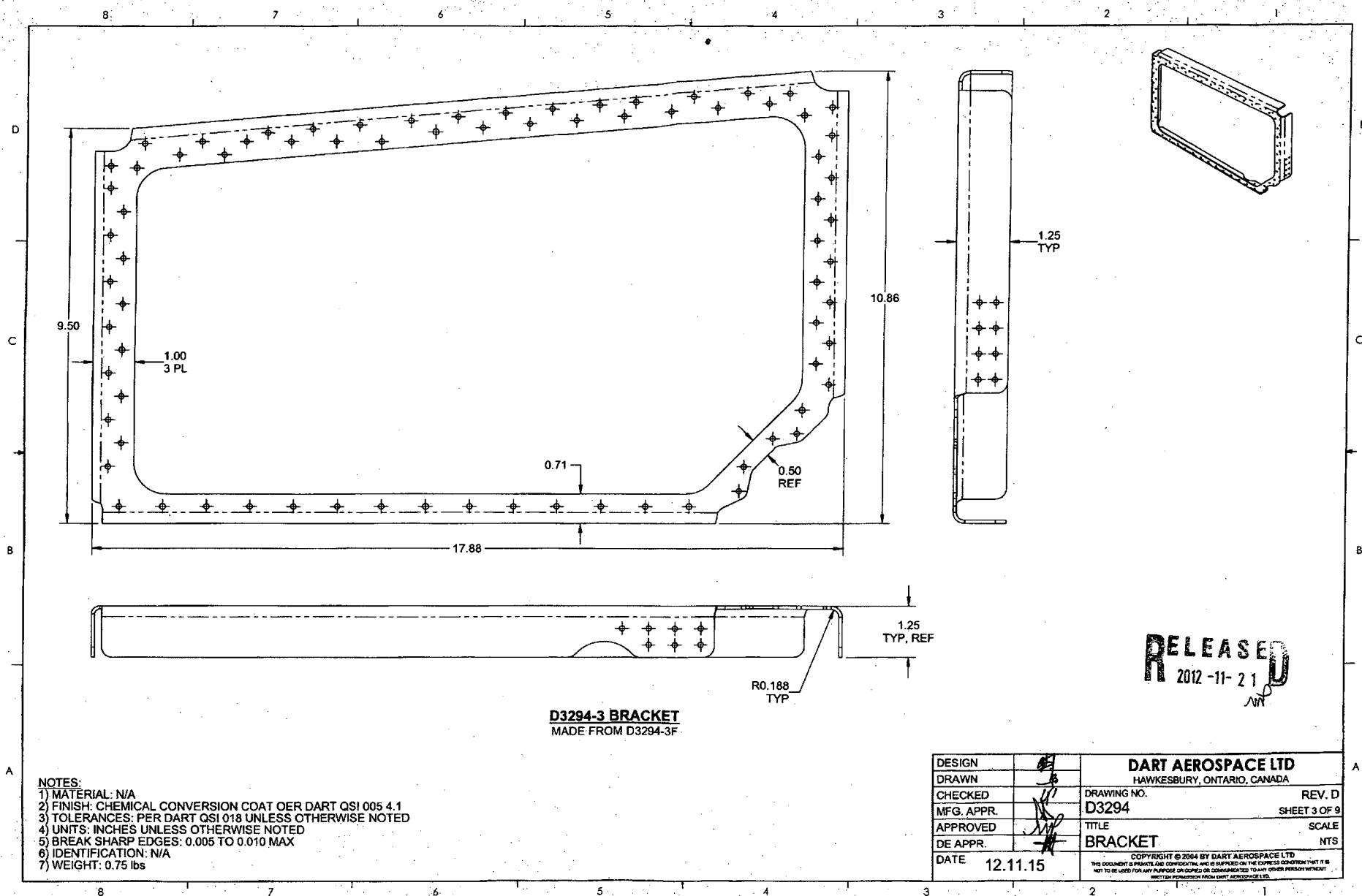
D3294-1B BRACKET ASSEMBLY, BLANK

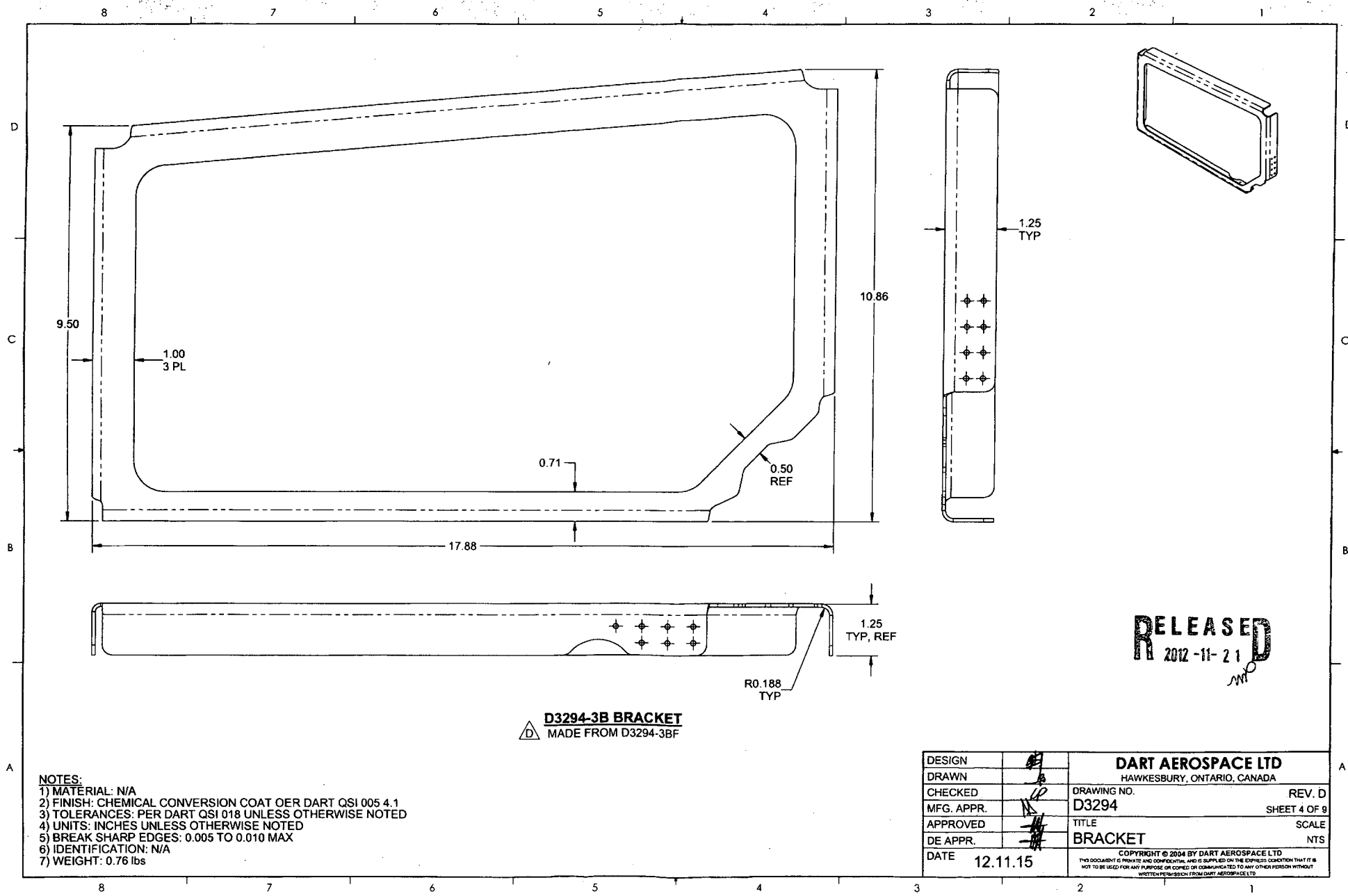
RELEASED
2012-11-21

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1B" PER DART QSI 044 6.1
- 7) WEIGHT: 0.83 lbs

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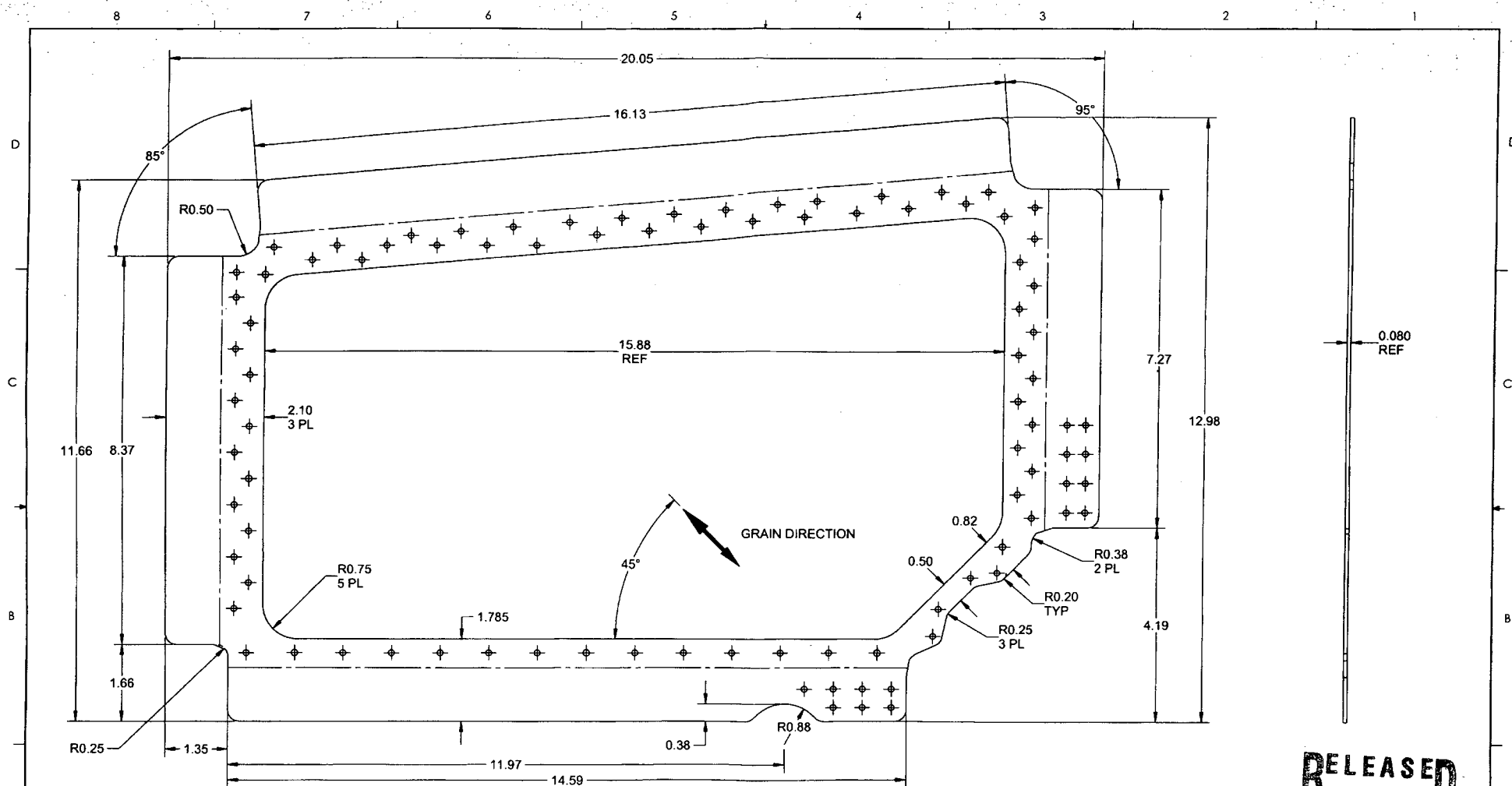


D3294-3B BRACKET
MADE FROM D3294-3BF

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT OER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.76 lbs

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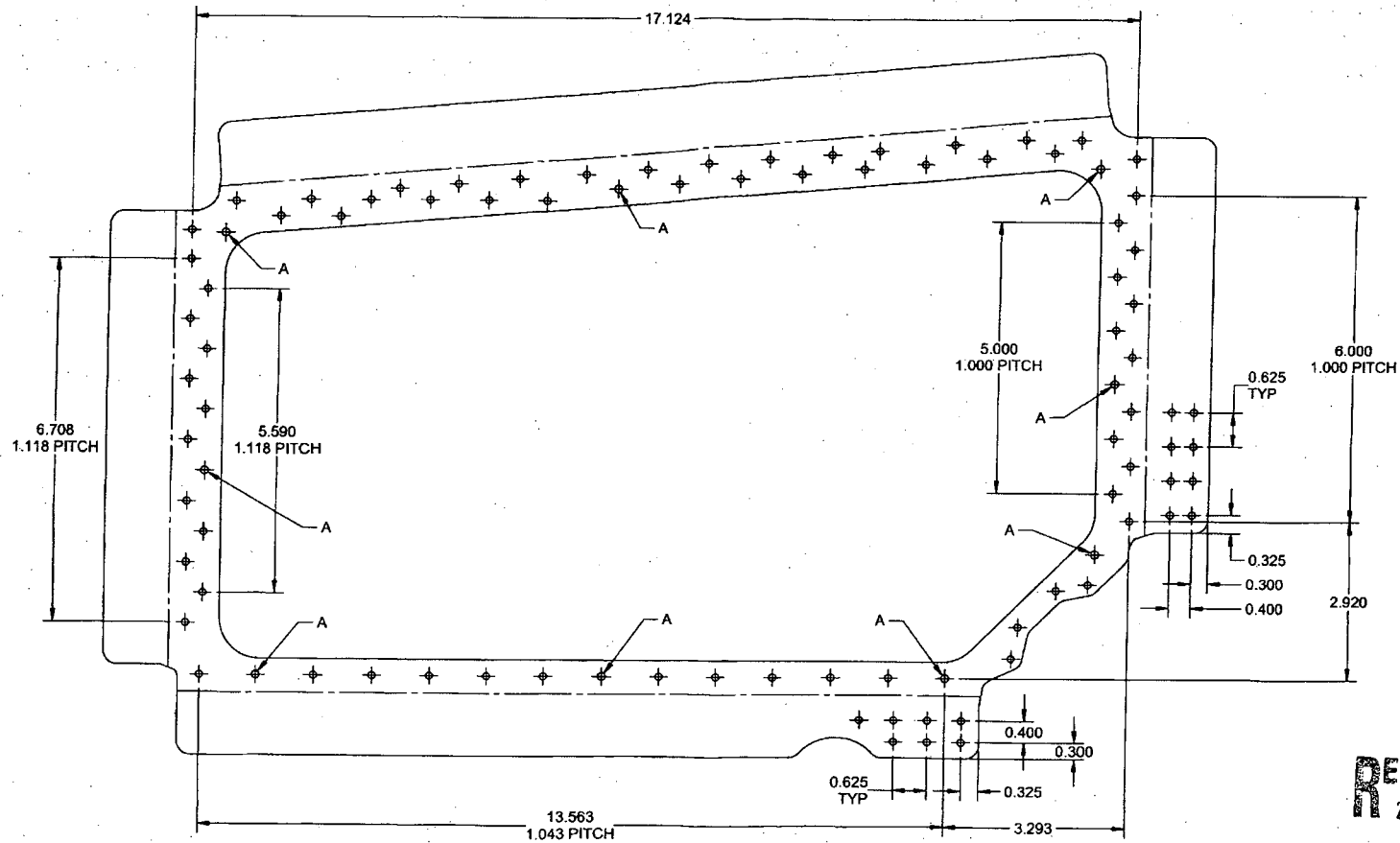
D3294-3F BRACKET FLAT PATTERN

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.75 lbs

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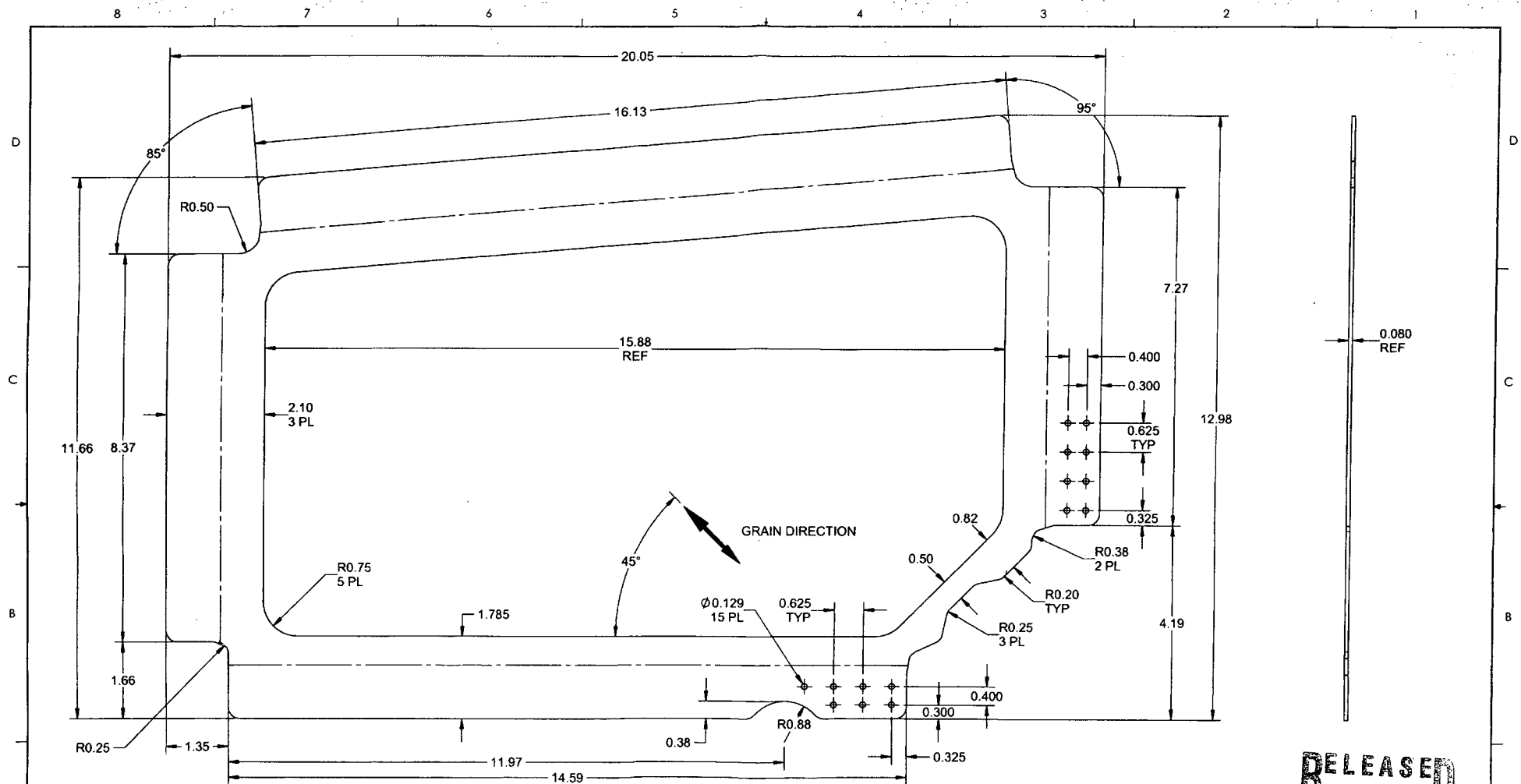


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LABEL	HOLE ϕ
ALL HOLES UNLESS NOTED	0.129
A	0.141

D3294-3F BRACKET FLAT PATTERN
SUPPLEMENTAL VIEW

DESIGN		DART AEROSPACE LTD	
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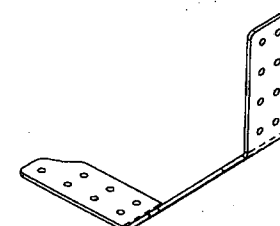
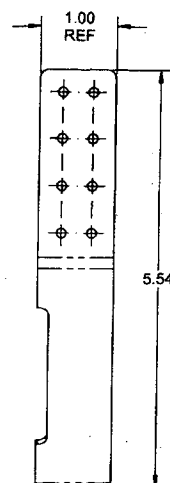
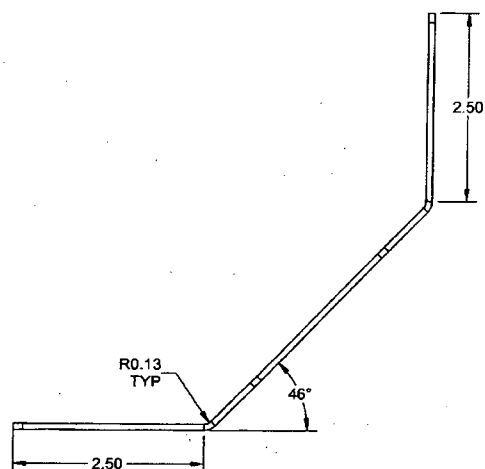
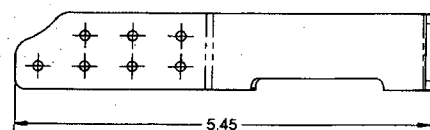
D3294-3BF BRACKET FLAT PATTERN, BLANK

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.75 lbs

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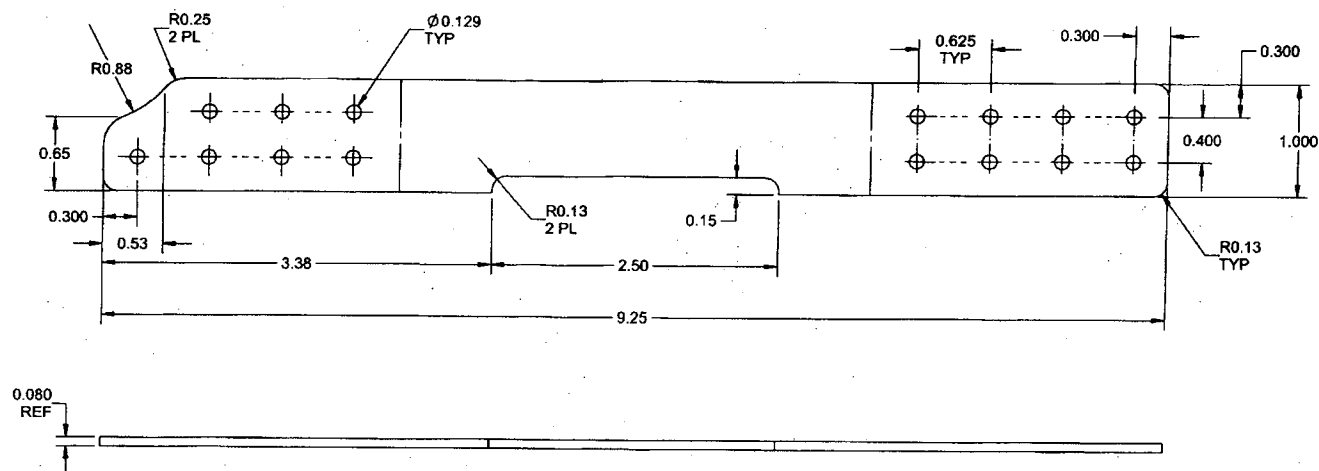
D3294-5 DOUBLER
MADE FROM D3294-5F

RELEASED
2012-11-21

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES; 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

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D3294-5F DOUBLER FLAT-PATTERN

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NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

DESIGN		DART AEROSPACE LTD	
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